

012048



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3372-041
Job Sheet 198792



Part No: D3372-041 **Job Qty:** 5 pcs
Part Name: Collective Lock As350

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 8/6/19 **Job Tracking No:**
Due Date: 9/18/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-13 JLM IPP Rev:B Added Key ID ____ 06.03.21 EC IPP
Rev:C added D3384-043 DD 10.05.13 verified :EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	5 pcs	9/18/19		0.00	2.08	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		SEP 23 2019
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	5 pcs	9/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		DAS 30 SEP 23 7:11
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Small Fab - 2 - B4B	5 pcs	9/18/19		0.00	2.08	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S216250



Part: D3372-041
Job No: 198792
Serial No/Batch: S216250
Revision:
Inspector:
Exp Date:
Instructions: Various STC's Date: 09/24/19

Plex 8/6/19 1:23 PM Dart.lajeunesse.marie

SEP 24 2019

6

140 Large Fab - Welded Assy-2-B4B	5 pcs	9/18/19	0.00 1.25	Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Large Fab - 1 - B4B	12
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
150 QC 9	5 pcs	9/18/19	0.00 0.00	Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				QC 9 - 10	
				QC 9 - 18	
160 Small Fab - 4 - B4B	5 pcs	9/18/19	0.00 1.56	QC 9 - 24	DAS 24 9-89
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 9 - 10	
165 QC 5	5 pcs	9/18/19	0.00 0.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	SEP 24 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
170 Packaging 3-1 - Stock - B4B	5 pcs	9/18/19	0.00 0.00	QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 9-89
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	5 pcs	9/18/19	0.00 0.00	QC 21 - SA - 21	SEP 24 2019	DAS
				QC 21 - SA - 70		70
				QC 21 - SA - 53		9-89

Part Op 100 - Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3
Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
120 - 1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2- Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5 3-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads Qty Part NumberDescription Batch A/R N/A Locktite 262 S157822 Identify as D3372-053 4-Assemble D3372-051 as per Dwg
exp: 01/20 140 - Tack weld lock shaft as per Dwg D3372 A/R SS Rod Batch _____
150 - (QC9- Inspect visual per QSI004- Fusion Welds)
160 - FINISH ASSEMBLY
165 - (QC5- Inspect part completeness to step on W/O)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5/16WC	Washer	10 Ea (2 ea)	100-Small Fab - 1	Q151170
AN5-42A	Bolt	5 Ea (1 ea)	100-Small Fab - 1	ST74152
D2728-7	Dart Logo Label	5 (1 ea)	100-Small Fab - 1	
D3369-5	Spacer	5 pcs (1 ea)	100-Small Fab - 1	S210406
D3372-1	Main Body	5 pcs (1 ea)	100-Small Fab - 1	S214646
D3372-5	Cam Lock Shaft	5 pcs (1 ea)	100-Small Fab - 1	S205526
D3372-7	Slider Body	5 pcs (1 ea)	100-Small Fab - 1	4x F163828-1x S213786
D3373-1	Cam Lock	5 pcs (1 ea)	100-Small Fab - 1	S204967
D3384-043	Cyclic Sock Assembly	5 pcs (1 ea)	100-Small Fab - 1	S204544
HX-81	1/4"-20 SHCS 3/8" long	5 Ea (1 ea)	100-Small Fab - 1	S173616
NAS1149F0463P	Washer (AN960-416)	10 Ea (2 ea)	100-Small Fab - 1	S201001

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	5/16WC	10	674	0
	AN5-42A	5	19	0
	D2728-7	5	0	0
	D3369-5	5	4	0
	D3372-1	5	0	0
	D3372-5	5	4	0
	D3372-7	5	4	0
	D3373-1	5	6	0
	D3384-043	5	0	0
	HX-81	5	23	0
	NAS1149F0463P	10	547	0
Part Specifications				
Specifications could not be found.				

Plex 8/6/19 1:23 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MIRB (QS1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐				Completed By Lead hand / Supervisor QC / QA Coordinator	